

5/32

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23813</b>
<b>Description:</b> Bearpaw Kit (19" x 24")	<b>Part Number:</b>	<b>K10008</b>
<b>Dwg:</b> D2432 Rev. F3	<b>Qty:</b>	<b>20 Kits</b>
<b>Ref:</b> K10008 Rev. E; DSK086-5 Rev. A		<b>Page 1 of 1</b>

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler <b>Note: (1) K10008 Kit consists of Qty (2) D2432F</b> <b>Dwg not required</b>	<i>[Signature]</i>	05.07.14	20																																																
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011  and create labels per PPP K10008 <b>CHG006</b> <b>(Bag Bluefiles separately)</b>	<i>UK 30 [Signature]</i> <i>DA</i>	05.07.28	20																																																
3	GA	<b>Cut 2 blanks per (1) K10008 Kit</b> Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: <i>M18612</i>	<i>M17227</i> <i>M17227</i> <i>me</i>	05/10/02	20																																																
4	MV	Inspect material for defects or damage prior to machining	<i>MS</i>	05/10/02	20																																																
5	MV	Machine as per Folio D2432 and Dwg D2432 <b>Identify as D2432F</b>	<i>MS/S</i>	05/10/02	20																																																
6	QC2	Inspect parts as they come off the CNC machine	<i>MS/S</i>	05/10/02	20																																																
7	MV	Deburr	<i>MS/S</i>	05/10/02	20																																																
8	QC8 & 5	Second inspection	<i>CS</i>	05/10/07	20																																																
9	KP	<b>Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3)</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td><i>B21872</i></td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td><i>(11) B23174 / B23372 (229)</i></td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td><i>B23813</i></td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td><i>(17) B22503 / B23175</i></td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td><i>B22504</i></td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td><i>B22505 / B24182 (24)</i></td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td><i>(12) M16067 / M17566 (228)</i></td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td><i>(19) M15422 / M15432 (48)</i></td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td><i>M17566</i></td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td><i>M15924</i></td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	<i>B21872</i>	12	D2274	Radius Block	<i>(11) B23174 / B23372 (229)</i>	2	D2432F	24" Bearpaw	<i>B23813</i>	6	D2438	Clamp	<i>(17) B22503 / B23175</i>	12	D2529	Washer	<i>B22504</i>	6	D2732-050	Rubber Cushion	<i>B22505 / B24182 (24)</i>	12	AN4-15A	Bolt	<i>(12) M16067 / M17566 (228)</i>	12	AN4-17A	Bolt	<i>(19) M15422 / M15432 (48)</i>	24	AN960JD416	Washer	<i>M17566</i>	12	MS21042L4	Nut (or -4)	<i>M15924</i>	1	Paperwork package from Step 2			<i>CS</i>	05/09/02	20
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10	QC4	Inspect Kit for 100% Completeness on the W/O	<i>SB</i>	05/10/11	20																																																
11	PK	Identify and pack for shipping as per PPP K10008 <b>REV. E</b>	<i>CS</i>	05/10/11	20																																																
12	AC	Cost / part <i>229.36</i>	<i>SAC</i>	05/10/12	20																																																
13	DC	Close W/O <i>229.80</i> Inspect Level 21	<i>(15)</i>	05/10/12	20																																																


Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	

RCP 0000525

**RELEASED**  
01.02.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 05/10/12

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	23813
Description: Bearpaw		Part Number:	D2432F
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.060"	✓			
B	5.500	+/-0.030	5.502"	✓			
C	0.200	+/-0.030	.195"	✓			
D	0.25 x 45°	+/-0.030	.25"	✓			
E	R0.250	+/-0.030	R.25"	✓			
F	0.250	+/-0.010	.253"	✓			
G	0.625	+/-0.030	.620"	✓			
H	0.375	+/-0.010	.380"	✓			
I	0.950	+0.030/0.010	.950"	✓			
J	19.000	+/-0.030	19.000"	✓			
K	3.14	+/-0.030	3.14"	✓			
L	3.28	+/-0.030	3.265	✓			
M	Ø0.260	+0.005/-0.000	Ø.260"	✓			
N	Ø0.93	+/-0.030	Ø.925"	✓			
O	0.30	+0.030/-0.000	.307"	✓			
P	23.750	+/-0.030	23.750"	✓			
Q	7.375	+/-0.030	7.375"	✓			
R	4.250	+/-0.010	4.254"	✓			
S	2.000	+/-0.030	2.018"	✓			
T	9.000	+/-0.010	9.000"	✓			
U	9.000	+/-0.010	9.000"	✓			
V	0.375	+/-0.010	.382"	✓			

Measured by: <i>MS</i>	Audited by: <i>gm</i>	Prototype Approval:	N/A
Date: 05/10/03	Date: 05/10/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/p200-559-015	KJ/RF

RELEASED

RT 04.01.15

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jul 14, 2005  
01:31 pm

Work Order No : 0023813

Project Name : K10008

Project For : WK532

Work Order Type : Main

Main WO Number :

House Part Number : \*K10008

Description : Bearpaw kit 19" x 24"

Manufactured : Yes

Amount Req'd : 20

Amount Done : 0

Start Date : 07-14-05

Est Finish Date : 08-20-05

Act Finish Date :

Drawings Req'd : No

Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount : 0.00

Order Entry No :

OE Value : 0.00

Est Mark Up : 0.000%

Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00